

Work Order ID 85095

85095

Page 1

June-01-12 3:42:57 PM

Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

JB Szlde lu

Car MLJ 12-6-6
⑥

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

6

12/06/08 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Szlde lu

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop *NS2*

Start Date: 01/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u> </u>								
	PPP Rev: <u> </u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/6/12
mf
12-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 1

Work Order ID: 85095

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Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

80.0000

12

12

✓

AN526C1032R7

Screw

**

JB

Location

Loc Qty

Loc Code

ST348

80

116304

8

119449

72

AN526C832R8

Purchased

No

120

Each

67.0000

48

48

✓

AN526C832R8

Screw

**

JB

Location

Loc Qty

Loc Code

ST346

63

120717

63

ST347

4

118926

4

AN526C832R9

Purchased

No

120

Each

336.0000

48

48

✓

AN526C832R9

Screw

**

JB

Location

Loc Qty

Loc Code

ST346

327

120181

27

121556

300

ST347

9

118983

9

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

0.0000

24

24

✓

AN960JD10

Washer

**

121524 JB

12/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85095

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Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

AN960JD8 NAS1149DN832 Purchased No

120 Each

0.0000

24 144 ✓

S to *AN960JD8*

Washer

D2143

Manufactured No

120 Each

35.0000

0 6 ✓

S to *D2143*

Hinge Bracket

**

120422 JB

**

JB

Location

Loc Qty

Loc Code

ST

-22

76100

16

ST004

19

82335

19

ST198

38

D2144

Manufactured No

120 Each

13.0000

0 6 ✓

S to *D2144*

Hinge Bracket

**

JB

Location

Loc Qty

Loc Code

ST005

13

78993

13

D2150

Manufactured No

120 Each

26.0000

2 12 ✓

S to *D2150*

Packer Doubler, Hinge

**

2x64764 JB 12/06/08

**

8x82136

Location

Loc Qty

Loc Code

ST005

26

76953

2

82136

24

2x76953

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85095

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

85095

D350-588-011

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2151 Manufactured No

120 Each

30.0000

2 12 ✓

D2151

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST005

30

76093

6

82137

24

5- ** 2x64310 JB
5- 4x82137

5- 6x76093

D2153 Manufactured No

120 Each

36.0000

6 ✓

D2153

Door Prop

Location

Loc Qty

Loc Code

ST272

36

78369

36

** 6 JB

78369 5- ✓

D2154 Manufactured No

120 Each

65.0000

6 ✓

D2154

Stud Bracket

Location

Loc Qty

Loc Code

ST005

65

77024

9

82333

56

** JB 12/06/08

77024 5- ✓

D2237 Manufactured No

120 Each

56.0000

2 12 ✓

D2237

Striker Plate

Location

Loc Qty

Loc Code

ST006

56

66139

1

82062

15

83376

40

** JB 12/06/06

82062 5- ✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 85095

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Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2461 Manufactured No

120 f

177.8967 7.25 45.78947 ✓

D2461
Neoprene "D" Seal

**

83816 JB

SCC

Location

Loc Qty

Loc Code

ST402

177.896684

39782

6.5

55054

4

63880

7.6237

73644

159.772984

D2463 Manufactured No

120 f

657.5468 7.25 45.78947 ✓

D2463
Seal

**

JB

Location

Loc Qty

Loc Code

ST404

657.54677

72232

15.38

79478

142.16677

83542

500

79478 SCC

D2583 Manufactured No

120 Each

27.0000 12 ✓

D2583
Latch Bracket

**

JB

12/06/06

Location

Loc Qty

Loc Code

ST011

27

82070

3

83445

24

2x 82070 SCC
9x 83445 SCC

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Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85095

85095

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2585

Manufactured No

120

Each

24.0000

12 ✓

**

JB

D2585

Mounting Channel

Location

Loc Qty

Loc Code

ST011

24

73297

2

83369

22

83369

D2586

Manufactured No

120

Each

19.0000

12 ✓

**

JB

D2586

Door Latch

Location

Loc Qty

Loc Code

ST203A

19

78833

19

78833

D2587

Manufactured No

120

Each

27.0000

6 ✓

**

JB

D2587

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST011

27

74522

1

78893

26

78893

D2589

Manufactured No

120

Each

0.0000

6 ✓

**

58194

12/06/06

D2589

Keys, Key Chain, 350 Hinge

D2690-17

Manufactured No

120

Each

26.0000

6 ✓

**

JB

D2690-17

Cables

Location

Loc Qty

Loc Code

ST016

26

66510

1

76139

5

84069

20

5x 76139

1x 84069

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85095

85095

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2857-1 Manufactured No

120 Each

34.0000

0 6 ✓

**

JB

D2857-1
Hinge Bracket

Location

Loc Qty

Loc Code

ST019

34

75253

10

82261

24

75253 ✓

D2857-2 Manufactured No

120 Each

22.0000

0 6 ✓

**

JB

D2857-2
Hinge Bracket

Location

Loc Qty

Loc Code

ST019

22

78904

22

78904 ✓

D2858-1 Manufactured No

120 Each

42.0000

0 6 ✓

**

JB

D2858-1
Hinge Bracket

Location

Loc Qty

Loc Code

ST019

42

77019

18

82337

24

77019 ✓

D2858-2 Manufactured No

120 Each

37.0000

0 6 ✓

**

JB 12/06/06

D2858-2
Hinge Bracket

Location

Loc Qty

Loc Code

ST019

37

77020

14

82336

23

77020 ✓

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 85095

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

85095

D350-588-011

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

FG-778150-550-ROL

Purchased

No

120

sf

2,873.071

1

6

~~*FG-778150-550-ROL *~~

7781 9oz Glass 50"x125yd

**

JB

Location

Loc Qty

Loc Code

CA

2873.071

104845

3

108932

18

111166

392

113905

563

117602

670.651

119099

1226.42

4-119099 S C

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased

No

120

Each

3,000.000

12

72

~~*MS20426AD3-4*~~

RIVET

**

JB

Location

Loc Qty

Loc Code

ST316

3000

104374

382

110398

2618

120

Each

1,494.000

18

108

MS20470AD4-5

Purchased

No

~~*MS20470AD4-5*~~

Rivet, Universal Head

**

JB

12/06/06

Location

Loc Qty

Loc Code

ST319

1494

118405

483

120142

1011

120142 S C

June-01-12 3:43:01 PM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 85095

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

85095

D350-588-011

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Purchased

No

120

Each

331.0000

108 ✓

MS210421 08

Nut

**

Location

Loc Qty

Loc Code

ST300

331

121444

131

121524

200

121444 S

MS21042L3

Purchased

No

120

Each

2,195.000

24 ✓

MS210421 3

Nut

**

Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

121349 S

MS27039-08-11

Purchased

No

120

Each

69.0000

12 ✓

MS27039-08-11

Screw

**

Location

Loc Qty

Loc Code

ST290

19

117441

19

ST292

50

120833

50

117441 S

June-01-12 3:43:02 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 85095

85095

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 6.00

Required Qty: 6.00

MS27039-1-15

Purchased No

120

Each

47.0000



12



MS27039-1-15

Screw

**

g B 12/06/06

Location

Loc Qty

Loc Code

ST291

47

118574

2

119736

1

121243

44

121243 S 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1	1	D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2	2	D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00